



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2876
Job Sheet 175177



Part No: D2876

Job Qty: 30 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B Esr Rev:B 00.05.19 Added inspect level 8 EC IPP Rev:C Now M6061-T6 06-06-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		4/12/18	0.00	0.00	Start Up Waterjet		pc 18/04/04
100	Waterjet	30 pcs		4/12/18	0.00	0.67	Waterjet1		pc 18/04/04
120	QC	30 pcs		4/12/18	0.00	0.00	QC8		38
140	HandFinish	30 pcs		4/13/18	0.00	0.30	HandFinish1		SIPAS-04-05
150	QC	30 pcs		4/13/18	0.00	0.00	QC7-1		11 APR 05 2018
160	Packaging	30 pcs		4/13/18	0.00	0.00	Packaging3	Stop	9-89
170	QC21-SA	30 Ea		4/13/18	0.00	0.00	QC21		APR 06 2018

Part Op Descriptions: 100 - 1-Cut as per Dwg D2876

DAS
21
9-89

APR 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	1.5480 sf (.0516 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.100	2	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.980Inches $\pm$ 0.030	1.010 0.950		
2	Saddle Spacer	1.000Inches $\pm$ 0.030	1.030 0.970		
3	Saddle Spacer	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
4	Saddle Spacer	3.360Inches $\pm$ 0.030	3.390 3.330		
5	Saddle Spacer	2.480Inches $\pm$ 0.030	2.510 2.450		
6	Saddle Spacer	0.555Inches $\pm$ 0.010	0.565 0.545		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

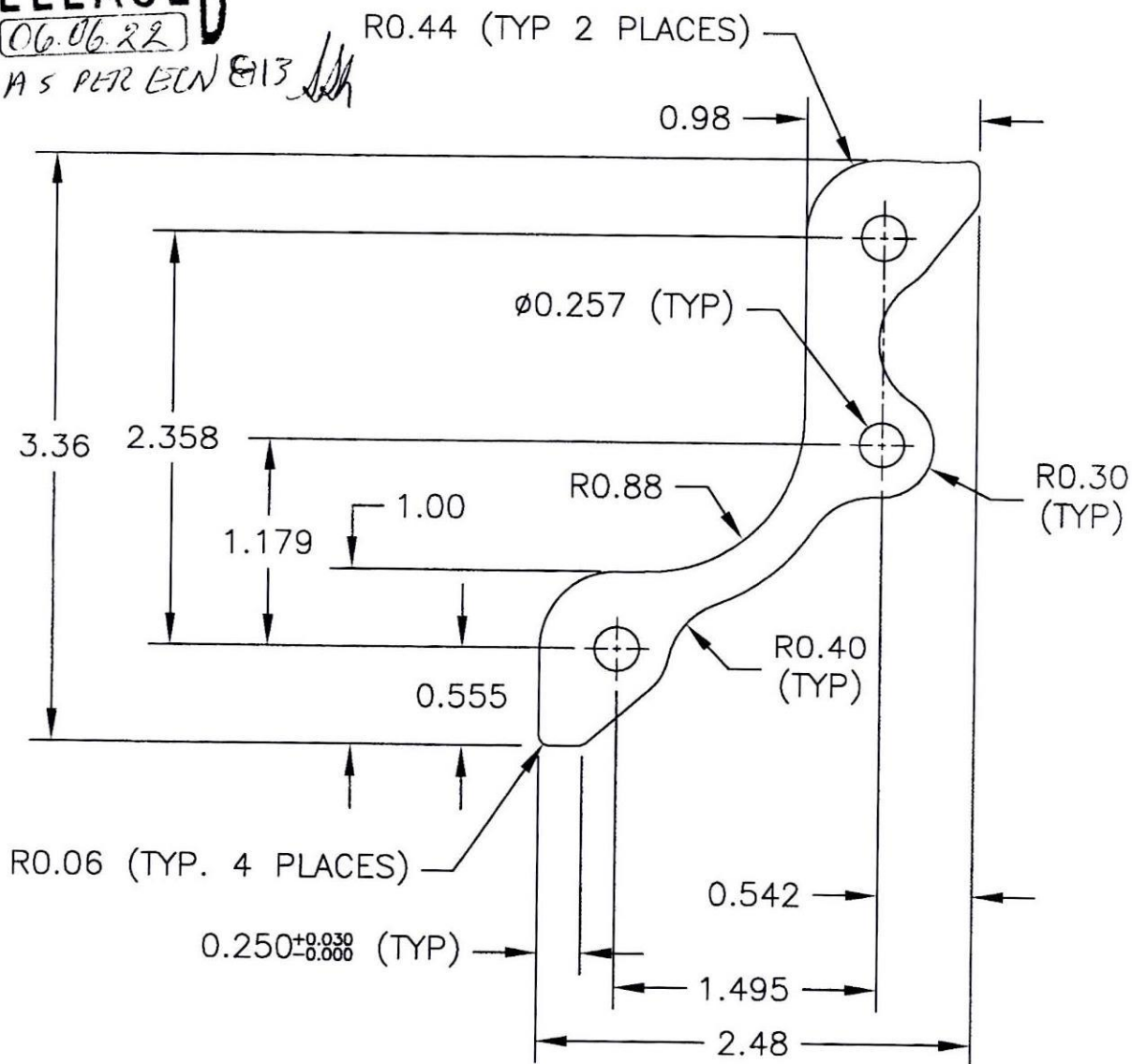
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td></td> <td>plier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐		plier ☐	
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Date : _____		Ste _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 																					
Description Work O DART Aerospace Ltd. 1270 Aberdeen Street Wexford, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 04/04/18 Container No: S057897 Part: D2876 Job No: 175177 Serial No/Batch: S057897 Revision: Inspector:																									
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>										Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐														
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OTHER : _____																									

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED
06.06.22AS PER ECN 813 *[Signature]***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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